

Work Order ID 77038

77038

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November-24-11 3:40:59 PM

Item ID: D2438 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Clamp
 Start Date: 24/11/2011 Start Qty: 50.00 ***50*** Cust Item ID:
 Required Date: 08/12/2011 Req'd Qty: 50.00 ***50*** Customer:
 Reference:

Approvals: Process Plan: M.L.J Date: 11/11/25 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2438	Rev C

100	PURCHASING	0.00							
100									
Waterjet	Memo	0.00							
FLOW CNC Waterjet	Cut as per dwg D2438								
304 . 063	prog rev: <u>E</u>								
	dwg rev: <u>E</u>								

110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC	Memo	0.00							
Quality Control	Ensure Material Release Note is attached								

120	QC8- Inspect parts - second check	0.00							
120									
QC	Memo	0.00							
Quality Control	(6.786" center to center)								

B12-1-3

(51)

B12-1-3

81260103

counted
(51)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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77038

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Accept

N900040100

Setup Start *NS1*

Stop ***NS2***

Cust Item ID:

50

50

Customer:

Reference:


Run Start *NR1*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

130	0.00	
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1000 Small Fab 

Small Fish	0.00	1	(36)			
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Small Pab	Memo	0.00	3/12/23	25	
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Small Fab 1- Use DT9713 clamp holder to hold clamp in place when forming
2- Bend as per drawing DT0700

140	QC5- Inspect part completeness to step on W/O	0.00	corrected
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110

0000 01260125 (75L)

	Memo	0.00	12-18-1977	12-18-1977	()
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Quality Control

150 Identify as per dwg & Stock Location: 456 0.00

150

Backlog 0.00

Packaging	Memo	0.00
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Category	Item	Quantity	Unit Price	Total Price
Packaging	Box	100	0.50	50.00
	Label	1000	0.05	50.00
Transportation	Truck	1	100.00	100.00
	Freight	1000	0.10	100.00
Insurance	Policy	1	50.00	50.00
	Premium	1000	0.05	50.00
Storage	Warehouse	1	200.00	200.00
	Rent	1000	0.20	200.00
Maintenance	Repairs	1	100.00	100.00
	Parts	1000	0.10	100.00
Miscellaneous	Supplies	1	50.00	50.00
	Tools	1000	0.05	50.00
Total				1000.00
				1000.00

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NOTE: Date & initial all entries

Work Order ID 77038***77038***

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November-24-11 3:40:59 PM

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.00							
Quality Control									

12/1/25 *[Signature]*
ME
12-01-25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

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Page 1

Work Order ID: 77038

77038

Parent Item: D2438

D2438

Parent Item Name: Clamp

Start Date: 24/11/2011

Required Date: 08/12/2011

Start Qty: 50.00

Required Qty: 50.00

Comments: IPP: E05.06.28Bending removedKJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304S16GA		Purchased	No			100	sf	303.6000	0.04	2.105263			
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M304S16GA

**

B12-1-3

304/316 Sheet .063

Location

Loc Qty

Loc Code

MAT020

303.6

119346

26.6

119653

277

11953 119653

(51)

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	77038
Description: Clamp		Part Number:	D2438
Inspection Dwg: D2438 Rev: C			Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

[illegible]

Measured by: <u>RB</u>	Audited by: <u>8</u>	Preliminary Approval:
Date: <u>12-1-3</u>	Date: <u>12/01/03</u>	Date:

Rev	Date	Change	Revised by	Approved
A	11.02.11	New Issue	KJ	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

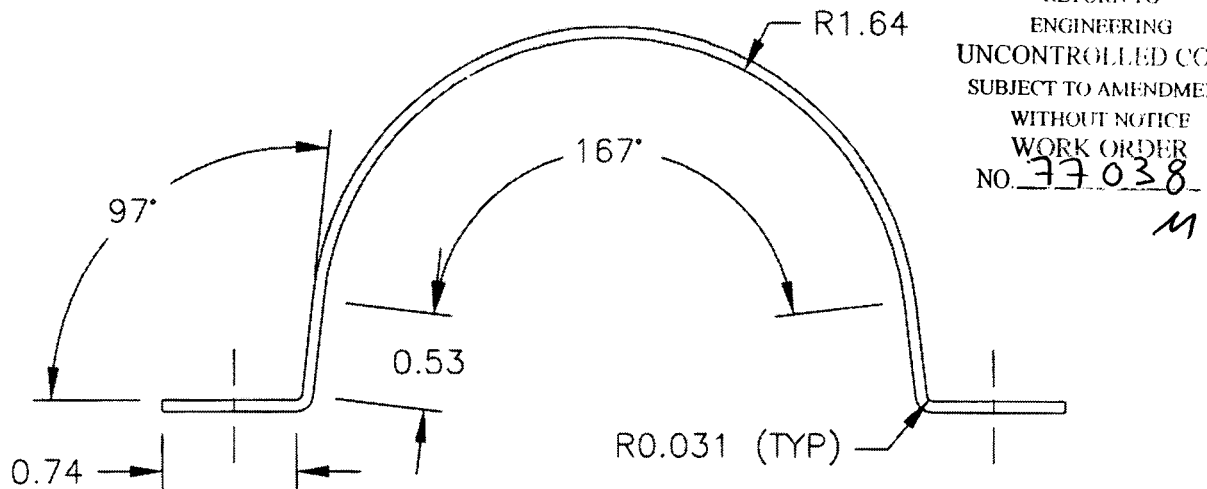
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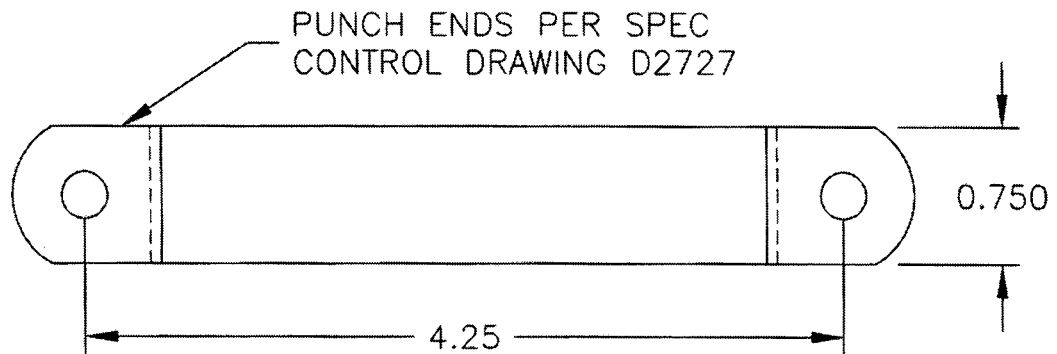


DESIGN <i>KE</i>	DRAWN BY <i>KE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>MB</i>	APPROVED <i>KE</i>	DRAWING NO. D2438	REV. C SHEET 1 OF 1
DATE 98.05.12		TITLE CLAMP	SCALE 1:1
A	96.01.24	NEW ISSUE	
B	96.05.13	CHANGE LENGTH	
C	98.05.12	R1.64 WAS R1.438, CHANGE GEOMETRY	

RELEASED
98.06.17 *KE*



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 37038
M



FLAT LENGTH: 7.586 END-END
6.786 HOLE-HOLE
6.529

MATERIAL: AISI 304/316 SS 0.063 THICK
MINIMUM REQUIREMENT IS ANNEALED CONDITION

00.06.06
CP 00.06.07

W/O:		WORK ORDER CHANGES					
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